

## Claims

1. A printing blanket assembly for a printing blanket cylinder of a rotary press, having a dimensionally stable carrier plate (02, 18) with two ends, of which one forms a leading end and the other forms a trailing end with respect to the rotation of the printing blanket cylinder, and which can be fixed to the printing blanket cylinder by turned-over limbs (21, 22) that are free of the printing blanket, and having a printing blanket (03, 19) fixed to the outside of the carrier plate (02, 18) and having a leading end (12, 31) and a trailing end (11, 32), characterized in that both ends (11, 12; 31, 32) of the printing blanket (03, 19) project beyond the turned-over edge (08, 09; 27, 28) of the associated limb (04, 06; 21, 22) of the carrier plate (02, 18), and in that in each case a supporting element (13, 14; 34, 36) for supporting the projection is arranged between the turned-over edge (08, 09; 27, 28) and the inner side of the printing blanket (03, 19).
2. The printing blanket assembly as claimed in claim 1, characterized in that the supporting elements (13, 14; 34, 36) fill up the interspaces between the turned-over edge (08, 09; 27, 28) and the projection of the printing blanket (03; 19).
3. The printing blanket assembly as claimed in claim 1 or 2, characterized in that the supporting elements (13, 14; 27, 28) are formed from a vulcanized rubber compound or a cured plastic compound.
4. The printing blanket assembly as claimed in one of claims 1 to 3, characterized in that the mutually facing side surfaces of two mutually facing

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5 supporting elements (34, 36) are designed to have shapes complementary to each other following the mounting of the printing blanket assembly (17) on the printing blanket cylinder and to virtually or just rest on each other.

10 5. The printing blanket assembly as claimed in claim 4, characterized in that the two supporting elements (34, 36) are produced from one workpiece by a dividing fabrication method, forming the mutually facing side surfaces.

15 6. The printing blanket assembly as claimed in one of claims 1 to 5, characterized in that the mutually facing side surfaces of the printing blanket (19) at the mutually opposite ends (31, 32) are designed to have shapes complementary to each other following the mounting of the printing assembly (17) on the printing blanket cylinder and 20 to virtually or just rest on each other.

25 7. The printing blanket assembly as claimed in claim 6, characterized in that the two ends (31, 32) of the printing blanket (19) are produced from one workpiece (24) by a dividing fabrication method, forming the mutually facing side surfaces.

30 8. A method for producing a printing blanket assembly as claimed in one of claims 1 to 3, characterized by the following method steps:

- The material of the printing blanket (03) is applied to the carrier plate (02).
- Ends of the carrier plate (02) that are free of the printing blanket (03) are turned over at the edge in order to form the limbs (06, 07) in such a way that the ends (11, 12) of the

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printing blanket (03) project beyond the turned-over edges.

- 5           - In each case a supporting element (13, 14) is introduced into the interspaces between printing blanket (03) and carrier plate (02) formed by the turned-over edges (08, 09).

10         9. A method for producing a printing blanket assembly as claimed in one of claims 1 to 7, characterized by the following method steps:

- 15         - The uncoated carrier plate (18) is fixed by the turned-over limbs (21, 22) to a fabrication cylinder, the shape of which corresponds to the printing blanket cylinder.
- 20         - The gap (26) between the opposite turned-over ends (27, 28) of the carrier plate (18) is filled with a supporting material.
- 25         - A printing blanket (19) is fixed to the carrier plate (18) in such a way that the leading and the trailing end (31, 32) of the printing blanket (19) project with the inner side beyond the turned-over edge (27, 28) of the associated limb (21, 22).
- 30         - Before or after the printing blanket (19) is fixed to a carrier plate (18), the supporting material is severed, forming two supporting elements (34, 36), and
- 35         - the carrier plate (18) is taken off the fabrication cylinder.

10. The method as claimed in claim 9, characterized in that, before the printing blanket (19) is fitted

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to the carrier plate (19), the printing blanket has a flat shape and, after the printing blanket (19) has been fitted to the carrier plate (18), the gap (26) between the mutually facing side surfaces at the mutually opposite ends (31, 32) of the printing blanket (19) is filled with sealing material (29), the sealing material (29) being severed in order to take the printing blanket assembly (19) off the fabrication cylinder.

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11. The method as claimed in claim 10, characterized in that, before or after being severed, the sealing material (29) is machined, in particular ground, forming a cylindrical peripheral surface.

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12. The method as claimed in claim 10 or 11, characterized in that the sealing material (29) is severed at the same time as the supporting material (24).

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13. The method as claimed in claim 9, characterized in that the printing blanket has a tubular shape before the printing blanket is fitted to the carrier plate (18).

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14. The method as claimed in claim 13, characterized in that the printing blanket is severed together with the supporting material.

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15. The method as claimed in one of claims 9 to 14, characterized in that, before the printing blanket (19) is fixed to the carrier plate (18), at least one foundation layer (24) is applied to the carrier plate, forming the supporting elements (34, 36).

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16. The method as claimed in claim 15, characterized in that the foundation layer (24) and the

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supporting material are formed simultaneously on the carrier plate (18) by using a uniform material.